

Sub Job 27 2017

Work Order ID 154689

154689

Page 1

Monday, December 19, 2016 3:56:20 PM

Item ID: D4634-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Middle, Center Ceiling Panel Assembly
Start Date: 1/3/2017 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 1/17/2017 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: VS Date: 16/12/20 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

1 DAS
6
9-89

JAN 12 2017

110

0.00

110

Small Fab

Memo

0.13

Small Fab

***BEFORE INTALLING D4728-051, APPLY A 3/16" SEEM OF PLASTIC-
WELD 2 ON TOTAL LENGHT OF PART ON EANCH SIDE OF LIGHT, LET
DRY FOR ONE HOUR***
PLASTIC-WELD 2 BATCH: 135436

1- Assemble as per Dwg D4634-043

2- Install led lights

3- Install Air valves

4-Install wiring harness

SMS
17/1/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Work Order ID 154689***154689***

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00				①	17-01-25		DAS 9 9-89
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									SMB 17/1/26
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							DAS 21 9-89
Quality Control									JAN 26 2017

DAS
21
9-89
JAN 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Monday, December 19, 2016 3:56:25 PM

Page 1

154689

D4634-043

Required Date: 1/17/2017

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL IPP Rev B
12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09
Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23
DL IPP REV E Dwg update 14/01/09
DL IPP Rev F Dwg. update 14/02/03
DL IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4652-5		Manufactured	No			100	Each	0.0000	2	2			
D4652-5 Air Valve, 1.25 Id Disk Type													
D4634-143		Manufactured	No			100	Each	0.0000	1	1			
D4634-143 Middle, Center Ceiling Replacement Panel Assembly													
D4646-1		Manufactured	No			100	Each	23.0000	2	2			
D4646-1 Plenum Cap Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF009		23							
				125003		11							
				152626		12							
D4728-053		Manufactured	No			100	Each	16.0000	1	1			
D4728-053 Cabin Lights #2													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF001		4							
				122551		4							
				over001		12							
				122551		12							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

Monday, December 19, 2016 3:56:25 PM

Work Order ID: 154689

154689

Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 1/3/2017

Required Date: 1/17/2017

Start Qty: 1.00

Required Qty: 1.00

PLT1.5M-M Purchased No

100 Each 2,735.000 3 3

PI T1 5M-M

Tie Wrap

DAS
6
9-89

JAN 12 2017

Location

Loc Qty

Loc Code

ST585

2735

m129712

2735

3

2351-20-27-C3C Purchased No

100 Each 55.0000 2 2

2351-20-27-Z3CT

2351-20-27-C3C

STUD

DAS
6
9-89

JAN 12 2017

Location

Loc Qty

Loc Code

ST579

55

m128068

11

m130318

44

2

50-009-2 Purchased No

100 Each 83.0000 2 2

50-009-2

Grommet

DAS
6
9-89

JAN 12 2017

Location

Loc Qty

Loc Code

ST582

83

m131501

23

m135442

60

2

DQA: _____ Date: _____



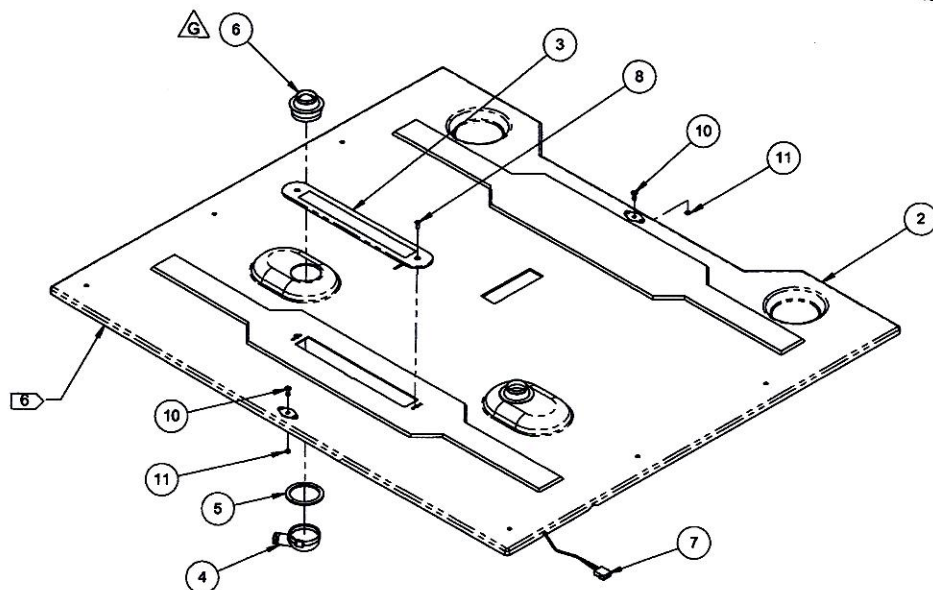
WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
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								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

ITEM NO.	QTY. -043	P/N	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-053)
4	2	D4646-1	PLENUM CAP ASSEMBLY
5	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
6	2	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
7	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
8	2	N/A (REF)	SCREW (PART OF D4638-1)
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
10	2	2351-20-27-C3C	DZUS STUD, OVAL HEAD
11	2	50-009-2	GROMMET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154689

*Wc
K.L.
16/12/20*

D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

RELEASED

2015 JAN 26 *ap*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 3 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

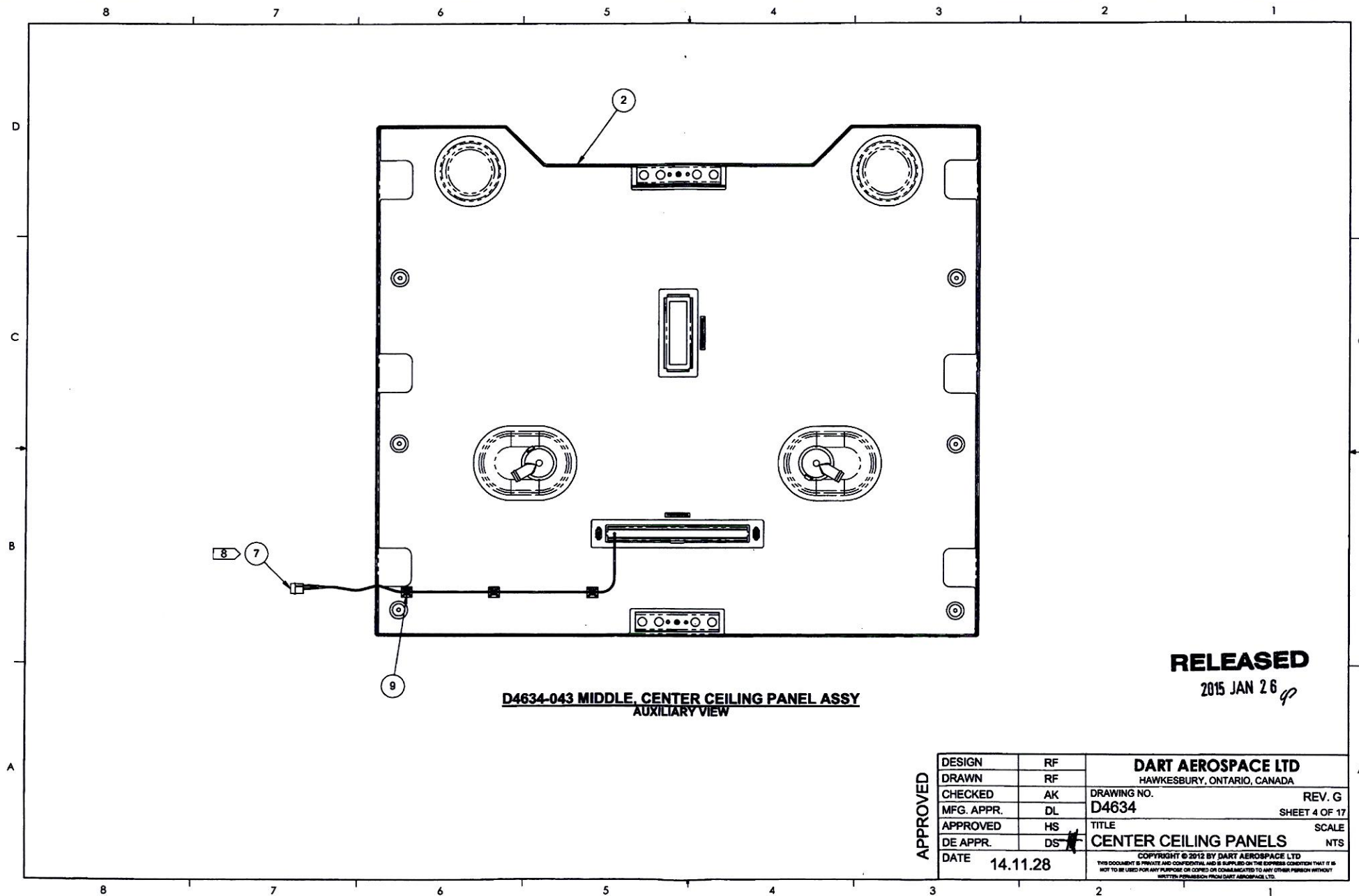
WORK ORDER NON-CONFORMANCE / UPDATE



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Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
WORK ORDER #1100110101 IF REF TO MEMO 1. CONTROLLED COPY 2. RETURN TO 3. SHOP COPY				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



RELEASED
2015 JAN 26 *gp*

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	AK	DRAWING NO.	REV. G
	MFG. APPR.	DL	D4634	SHEET 4 OF 17
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CENTER CEILING PANELS	NTS
	DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMINGLED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Misidentified ☐	Past Due ☐																																																																

Daryl Leger

From: David Shepherd
Sent: Thursday, May 14, 2015 12:35 PM
To: Nigel Forbes; Bill Beckett
Cc: Roberto Fuentes; Linda Lacelle; Mario Poulin; Daryl Leger; Harvey Siemens
Subject: RE: 139 Ceilings Deviation

Nigel,

Thanks for the clarification. I have a much better understanding of what happened here. My assumption had been that we were holding off ordering parts until the newer, cheaper parts were approved so that we could reduce our costs. There is certainly no Engineering objection to using the existing stock.

On the lights, the part number did not change (still D4638-1) even though the supplier did, so this is not a deviation. Both the Bruce p/n and Emteq p/n are acceptable.

On the vents, the part number changed from D4652-1 to D4652-5 because the appearance of the part was quite different, so all drawings now call up D4652-5. Suggest we get Roberto to issue a DEO that allows the D4652-1 to be used in place of D4652-5 until stock is depleted.

In both cases, we should set aside a portion of the old stock to support customers who already have the kits. Maybe 10 of the lights and 30 of the vents, or something like that.

Regards,
David

From: Nigel Forbes
Sent: May-14-15 8:31 AM
To: David Shepherd; Bill Beckett
Cc: Roberto Fuentes; Linda Lacelle; Mario Poulin; Daryl Leger; Harvey Siemens
Subject: RE: 139 Ceilings Deviation

David,

Apologies for the delay in replying. After reviewing the history on these items, here's the background:

- The lights, long lead time (90+ days) and minimum quantities to get them at \$765 a piece. Plus, these had to be shipped to Mr. Rowe to incorporate in the harnesses and that added to the lead time. So again, we placed blanket P.O based on forecast and we ended up with the these quantities and we can't return them. See below.

From: Shonda Wallace/ATL/Satair <sow@satair.com>
Date: May 14, 2015 at 10:09:59 AM EDT
To: Linda Lacelle <llacelle@dartaero.com>
Subject: RE: BR9741-401-001

Linda,

Unfortunately we do not buy parts back.

Best regards,

Shonda Wallace
Customer Order Specialist

Tel: +1 404 675 6328